

20-8062



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

649.8310

Job Sheet 198169



Part No: 649.8310

Job Qty: 20 pcs

Part Name: Cutter Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/23/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/23/19

Type: Stock

Description:

Note: DWG REV n/c IPP REV:A NEW ISSUE 13-10-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

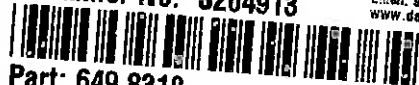
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		8/23/19	0.00	0.80	Bandsaw - 1	52.9-89	17/08/13
110	HAAS 4 Axis - B4B	20 pcs		8/23/19	1.00	29.41	HAAS - 1 - B4B	52.9-89	17/08/13
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs		8/23/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S204913



Part: 649.8310

Job No: 198169

Serial No/Batch: S204913

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/13/19

Plex 7/23/19 9:29 AM Dart.lajeunesse.marie

130 QC 8	20 pcs	8/23/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	OK 19/08/18
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Outsource - 4 - Anodize	20 pcs	8/23/19		ATG001-VC	2019-08-20
150 Packaging 2-1 - Receive - B4B	20 pcs	8/23/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP AUG 28 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	

						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
155	QC 5	20 pcs	8/23/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
180	Packaging 3-1 - Stock - B4B	20 pcs	8/23/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190	QC 21 - SA	20	8/23/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Bandsaw)Cut Blank at 7.425" Descriptions: 110 - (HAAS CNC Vertical Machine)1-Machine per folio FB224 DWG REV: <u>NC</u> FOLIO REV: <u>AA</u> 2- deburr and break all sharp edges 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check					

AUG 28 2019

140 - Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 44290 1- Black Anodize as per Dwg 646.9700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required
150 - Receive & Inspect for Damage & Mat'l Certs
155 - QC5- Inspect part completeness to step on W/O
180 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	12.4000 ft (.62 ea)	100-Bandsaw - 1	5129443 X 6 5183848 X 11

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.000X5.000	12	38	0

Part Specifications

Specifications could not be found.

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Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044290



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044290

PO Date: 8/20/19

Due Date: 8/27/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198169	649.8310	Cutter Body : Various STC's Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 1- Black Anodize as per Dwg 646.9700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed	-	8/27/19	20 pcs	0 pcs	20 pcs	\$18.66/pcs	\$373.20
2	197337	D4842-1	Lower Cutter Deflector Outsource process- Issue P/O to ATG : HARD ANODIZE COLOR BLACK, PRIME AS PER DWG D4842	Firmed	-	8/27/19	10 pcs	0 pcs	10 pcs	\$16.21/pcs	\$162.10

Grand Total: \$535.30



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PURCHASE ORDER

POHB044290



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/27/19 3:51 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918468

Date: 26-Aug-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 649.8310 Cutter Body Hard Anodize IAW MIL-A-8625 Type III, Class 2, Color Black Prime IAW MIL-P-23377J Type I Class N; 1-2 Mil Max Job: 25850 PO: POHB044290	Rev: NC	Line: 1
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>AUG 26 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

2AS
DAS
811
9-89

RECEIVED
AUG 27 2019
DART AEROSPACE LTD.

Made in Canada.

Entered: 2K Date: HA 7/2020



NCR No. 20-8062

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>198169</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>649.8310</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: <u>19/08/08</u>	Sequence #: <u>1</u>		QTY Affected: <u>1</u>		MRB (QSI042) DAS 55 9-89 OCT 7 8 2019 Completed By S.C 19/08/08 Lead hand / Supervisor DAS 20 9-89 19/08/08 QC / QA Coordinator DAS 55 9-89 MAR 24 2020		
Description Work Order Deviation			Disposition				
Top groove is .008 off center			Scrap and replace				
Root Cause		FAULT CATEGORY					
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Manufacturing Process ☒	Bending ☐	Misaligned/off center ☒	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Presservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details:						